

Work Order ID: 89761

89761

Page 1

September-05-12 10:00:37 AM

Item ID: D3322-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod Assembly
 Start Date: 9/05/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2202	REV G
D3322	Rev A

100 PURCHASING 0.00
 100 0.00
 Purchasing
 Purchasing
 Memo
 Issue P/O: 17847
 Description: D2202-1 Pod Lid D2202-5 Pod Base
 Supplier: Delastek
 Copy of Certificate of Conformity and Process sheet from Delastek is required
 SHIP TO DELASTEK QTY (1) D3048-1 685393
 QTY (3) D3001-1 685393

11-12-09-5

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110 0.00
 Packaging
 Packaging
 Memo
 Ensure certificate of conformity and process sheet from Delastek is attached

11/19/5 ①

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo Visual inspection. Check for void spot and pins. Check over all dimensions as per Dwg D2202. PICK Kit	0.00 0.00	DAS 16 9-89	12/12/06		(4)			
130 *130* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D2694 & D3322	0.00 0.00		12-12-06		1			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				DAS 11 9-89		12-12-10	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 3

September-05-12 10:00:37 AM

Item ID: D3322-041 Accept *N900040100* Setup Start *NS1*
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
 12/12/11 (1)
 12/12/11
 12/12/11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 1

Work Order ID: 89761

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/05/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A04.11.12New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

~~AD62ABS~~
rivet

Purchased

No

130

Each

147.0000

38

38

.

Location

Loc Qty

Loc Code

ST281

147

116055

5

121913

42

122356

100

M123369 (1-18) 12-12-10
18
20x SP

~~AD64ABS~~
Pop Rivets

Purchased

No

130

Each

182.0000

43

43

Location

Loc Qty

Loc Code

ST281

182

116166

182

M112787

14 12-12-10
43 29x

AD66ABS
POP RIVET

Purchased

No

130

Each

0.0000

2

2

~~AN4-5A~~
Bolt

Purchased

No

130

Each

832.0000

19

19

12-12-10
SP

Location

Loc Qty

Loc Code

ST355

832

120562

832

19x

~~AN4-6A~~
Bolt

Purchased

No

130

Each

1,424.0000

1

1 12-12-10
M123248
SP

Location

Loc Qty

Loc Code

ST355

600

122808

600

ST356

824

121243

500

122151

324

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

September-05-12 10:00:36 AM

Page 2

Work Order ID: 89761

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/05/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

~~AN526C632R7~~

Purchased

No

130

Each

160.0000

2

2

SP

Screw

Location

Loc Qty

Loc Code

ST347

160

112385

102

2x

117317

58

AN960JD416

~~NASH49D0463J~~

Purchased

No

130

Each

29.0000

21

21

m/23355 SP

Washer

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

D2202-1P

Purchased

No

110

Each

0.0000

1

1

Side Pod Lid, 350

D2202-5P

Purchased

No

110

Each

0.0000

1

1

SIDE POD, BASE 350

~~D2204-9~~

Manufactured

No

130

Each

39.0000

5

5

SP

Latch, Rubber

Location

Loc Qty

Loc Code

ST204

15

80153

15

5x

ST240

24

85081

24

D2429-041

Manufactured

No

130

Each

8.0000

1

SP 12-12-6

Spring Clip Assembly

Location

Loc Qty

Loc Code

ST009

8

36272

2

81895

6

1x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced							
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure							
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld							
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled							
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Positioned Wrong							
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other							
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread									
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset									
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration									
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence									
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions									

Picklist Print

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Work Order ID: 89761

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/05/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

~~D2462~~
Seal *D2462*
per drug

Manufactured No

130 f 315.9344 14.17 14.17

Location Loc Qty Loc Code

ST404 315.9344

46530 315.9344

Manufactured No

130 Each 35.0000

5 5

Location Loc Qty Loc Code

ST010 35

82334 21

85128 14

Manufactured No

130 Each 18.0000

4 4

Location Loc Qty Loc Code

ST010 18

65085 18

Manufactured No

130 Each 2.0000

1 1

Location Loc Qty Loc Code

ST489A 2

86067 2

Manufactured No

110 Each 10.0000

3 3

Location Loc Qty Loc Code

ST178 10

63870 5

85393 5

Manufactured No

130 Each 3.0000

1 1

Location Loc Qty Loc Code

ST265 3

84300 3

~~D2528-1~~
Backer Plate

~~D2528-3~~
Backer Plate

~~D2569~~
Hinge

~~D3001-1~~
Doubler

~~D3007-041~~
Strut

15.90 12-12-10
SP

5x
SP

4x
SP

1x
3

85393
SP 12-12-6

1x

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Shop Packet Print

Page 3

NCR: Yes / No

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Page 4

Work Order ID: 89761

Parent Item: D3322-041

Parent Item Name: Pod Assembly

Start Date: 9/05/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

D3048-1 Manufactured No
Doubler

110 Each 1.0000

1

1

Location

Loc Qty

Loc Code

ST139

1

52223

1

52223

~~MS21042L06~~

Nut

Purchased No

100 Each 549.0000

2

2

Location

Loc Qty

Loc Code

315

282

122441

282

ST300

67

121556

67

ST317

200

122151

200

2x

~~MS21042L06~~

Nut

Purchased No

130 Each 4,246.0000

20

20

Location

Loc Qty

Loc Code

314

4231

122452

4231

ST300

15

121444

15

m/23021 SP

~~NASH149DN6323~~

Washer

Purchased No

130 Each 296.0000

2

2

Location

Loc Qty

Loc Code

298

200

122441

200

ST298

96

118428

96

m/D3900 SP

12-12-6

September-05-12 10:00:36 AM

Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816,
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,
OR DIVINYCELL,
OR AIREX,
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

also 89761

RELEASED
2010-10-28

G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

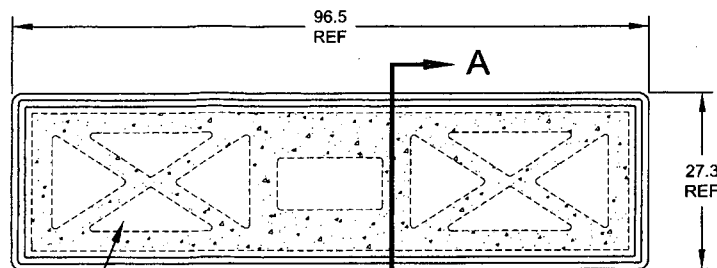
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

SEE
DETAIL B
A8-2

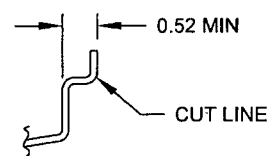
SECTION A-A C3-2



D2202-101 FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8024

6.0 REF

D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 10X D6-2

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-101 FOAM CORE
5oz KEVLAR
9oz SATIN

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

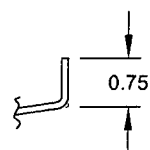
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Equip/Tooling <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

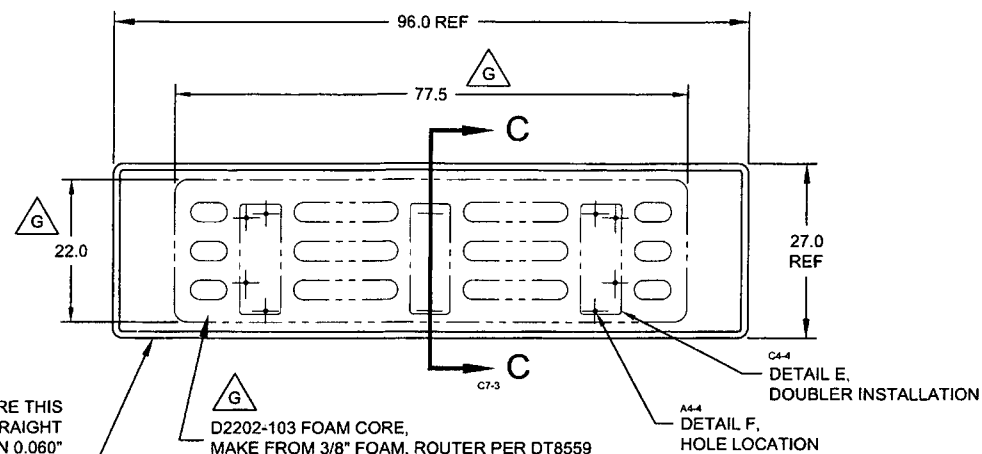
SEE
DETAIL D
B7-3

SECTION C-C C4-3

ENSURE THIS
EDGE IS STRAIGHT
WITHIN 0.060"
AFTER TRIMMING



DETAIL D
SCALE 10X D7-3



D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2202-103 FOAM CORE
5oz KEVLAR
5oz KEVLAR
9oz SATIN

RELEASED
2010-10-28

DESIGN		KE	DART AEROSPACE LTD	
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		JP	DRAWING NO.	REV. G
MFG. APPR.		JM	D2202	SHEET 3 OF 5
APPROVED		JP	TITLE	SCALE
DE APPR.		JP	UTILITY POD LID AND BASE	NTS
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NCR: Yes / No

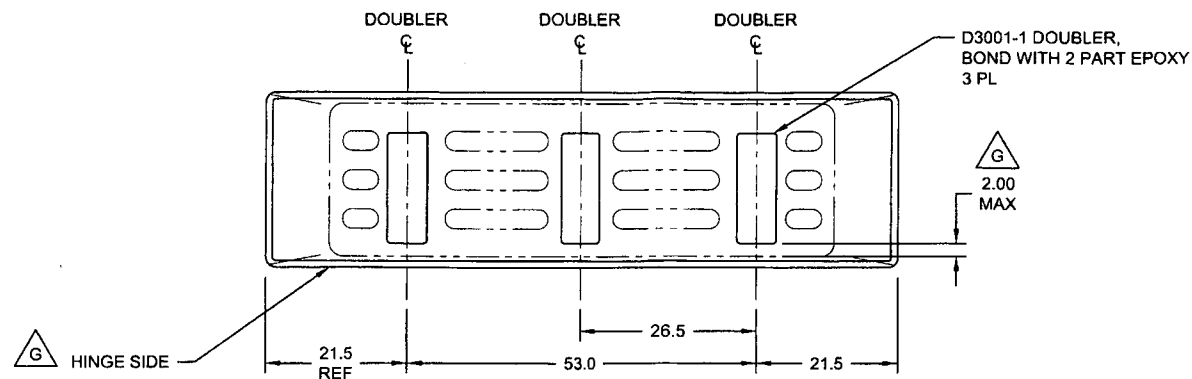
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

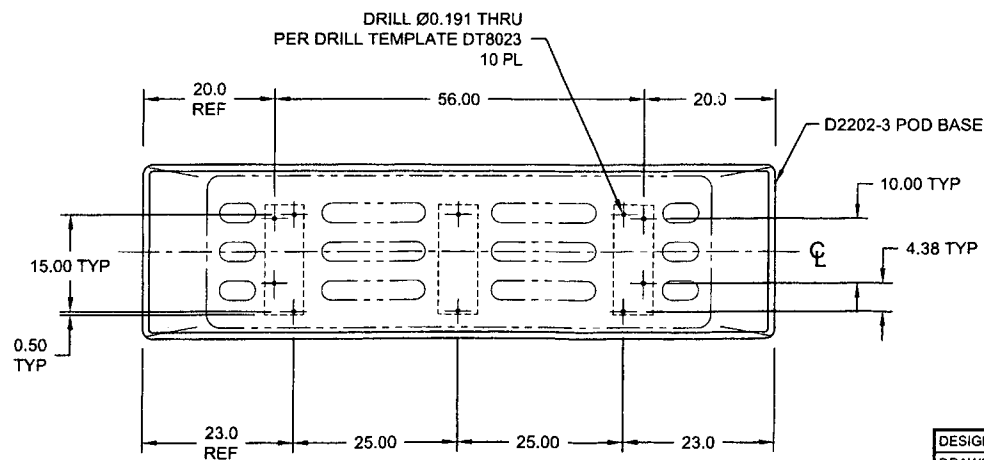
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	



DETAIL E: INSTALLATION OF D3001-1 DOUBLERS C3-3



DETAIL F: HOLE DRILLING C3-3
(AFTER DOUBLER INSTALLATION)

RELEASED
2010-10-28

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

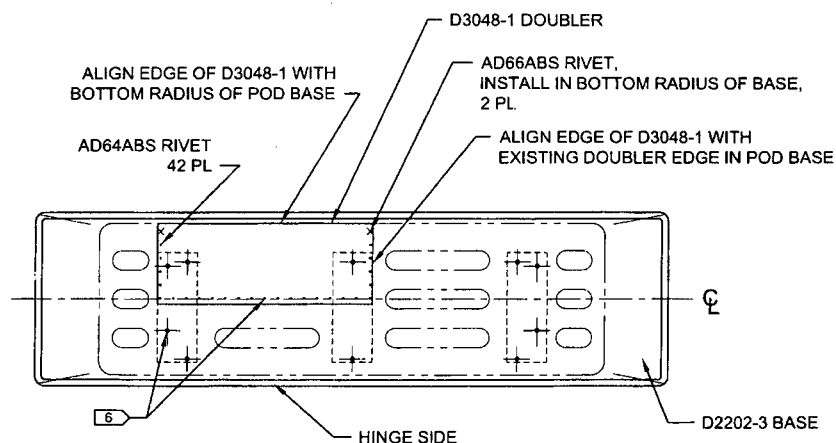
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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NOTES : TO MAKE A D2202-5/-6 BASE (FOR D350-602-013/-014) FROM A D2202-3 BASE

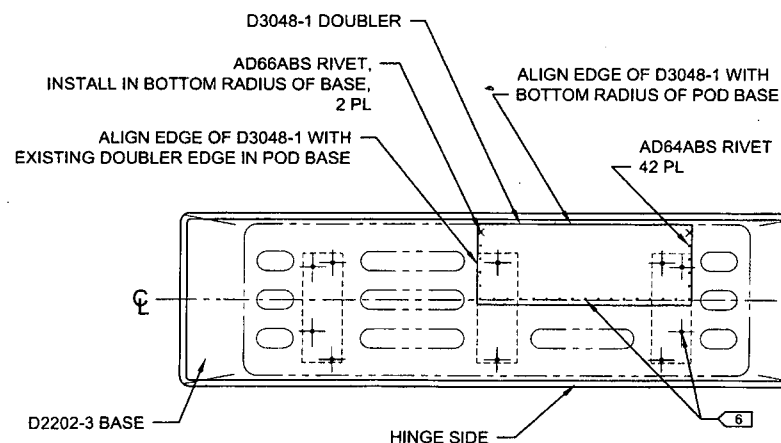
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

PART LIST:

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



D2202-5 BASE: D3048-1 DOUBLER INSTALLATION (MAKE FROM D2202-3 BASE)



D2202-6 BASE: D3048-1 DOUBLER INSTALLATION (MAKE FROM D2202-3 BASE)

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

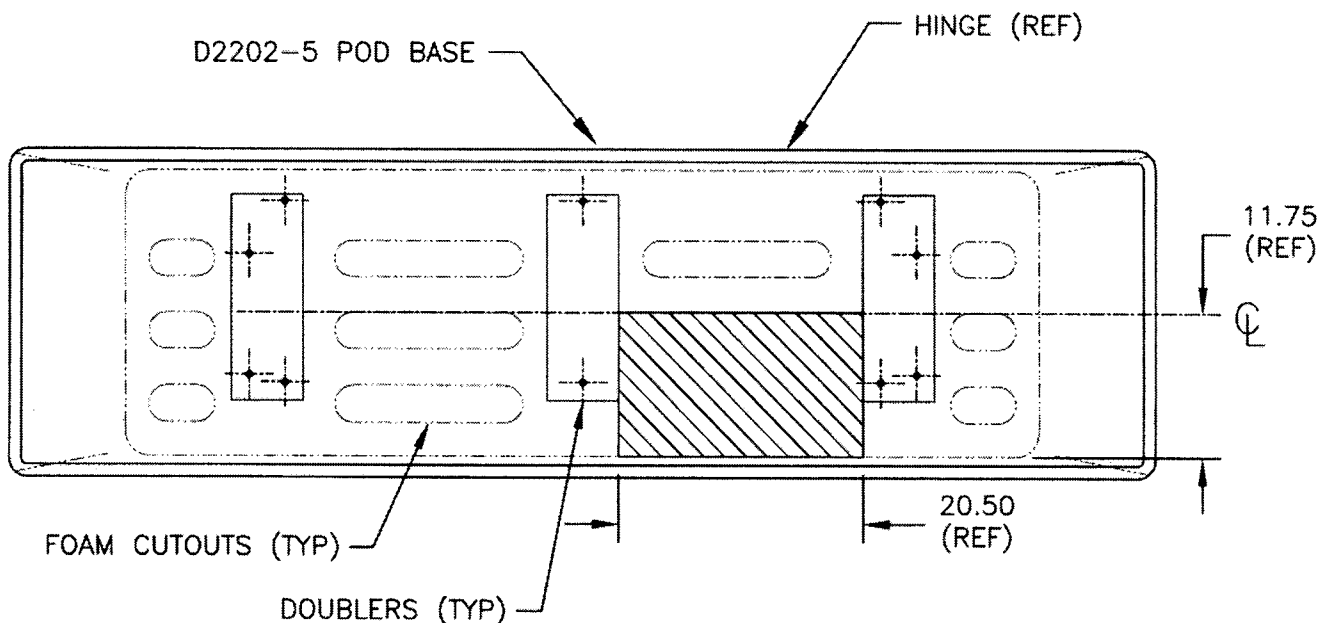


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED
04.10.29

D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE



D3322-041 POD ASSEMBLY (SHOWN)
D3322-042 POD ASSEMBLY (OPPOSITE)

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17847**

Purchase Order Date 9/6/2012

PO Print Date 9/6/2012

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
6/21/09/04

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2202-1P	Side Pod Lid, 350	10/5/2012 Yes	1.00 Each	FedEx PI collect	\$2,828.3800	\$2,828.38
		Special Inst:	As per DWG: D2202 Rev: G B89761				
2	D2202-5P	SIDE POD, BASE 350	10/5/2012 Yes	1.00 Each	FedEx PI collect	\$2,828.3800	\$2,828.38
		Special Inst:	Same as above				
						PO Total:	\$5,656.76

Change Nbr: 1

Change Date: 9/6/2012

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	45519
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
30-10-2012	11-09-2012	21666	Brigitte Golden	PO17847	Net 30 days USA
Ship Via		F.O.B.	Salesperson		GST/PST
FEDEX P1 Collect		Origin	Mathieu Veilleux, ext. 235		
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0073	Line #1 D2202-1 Side Pod Lid B89761 U of M: Chaque Référence DKA362-0015 DWG: REV. G Lot # 44975	
1	0	1	DKC134-0075	Line #2 D2202-5 Side Pod Base B89761 U of M: Chaque DWG: D2202 Rév.: G Lot # 44976 51212106	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department



AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Vendredi, 2012-09-21 10:04:21
 Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE	Nom Dessin :	UTILITY POD LID
Numéro Job :	44975	Numéro Article :	DKC134-0073
Numéro :	4347	Numéro Dessin :	D2202
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2012-09-21 No. :	Révision dessin :	G
Prsht Rev. :	NC	Matériel :	Resine Darakane 470-36/411/510
Prem. fois :	-- Type :	Date Due :	2012-09-28 Qté: 1 Ud UNITE
Job précédente :	42020		
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de Pièce Client: D2202-1		

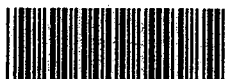


COPIE

 Process Sheet Rév.: 03 Ajout de la IF134-0008 à la
 séquence 35.0.






Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment	Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s) N° 83634, Frekote Loctite Wolo # de Lot: 1-33185-1	
2.0	PREP-GENERAL	Préparation du matériel
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation du moule N° DT 8002 selon IG 0009. Date: 25/09/12 Sceau:	
3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
Comment	Qty.: 1.250 KILOGRAMME(s)/Unit Total: 1.250 KILOGRAMME(s) Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-37214-2	
4.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-2824-1	
5.0	GEL COAT	Application du Gel Coat
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Appliquer le gel coat selon IG 0019. Date: 25/09/12 Sceau:	

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	UTILITY POD LID
Numéro Job:	44975	Numéro	DKC134-0073
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment	Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-36339-2</u>		
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>N/A</u> 		
8.0	AAC1608	5oz plain weave Kevlar 50" wide roll	
Comment	Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s) 5oz plain weave Kevlar 50" wide roll N° de Lot: <u>1-28178-1</u>		
9.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u> 		
10.0	AC0885	Feutre de drainage N° Airweave N°40	
Comment	Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)		
11.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment	Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)		
12.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)		
13.0	TAILLAGE	Faire le taillage du matériel	
 			

Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 24-09-12 Sceau:



J.C

14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-37405-8

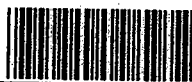
15.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid :
1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Date: 26-09-12 Sceau: NT 4102

AM 4297



17.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar)
de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350
Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre
avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin
)

Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)

Date: 26-09-12 Sceau: NT 4102

AM 4297



18.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher 4 heures minimum

Date: 26-09-12 Sceau: NT 4102

AM 4297



Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

19.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-37405-2

20.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0

DKC134-0022

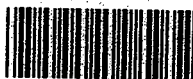
D2202-101 Foam Core (Utility Pod Lid)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
D2202-101 Foam Core (Utility Pod Lid) N° de Job: 44999

22.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 1.5% de catalyst
DDM-9 par quantité de résine.

Date: 26-09-12 Sceau: NT 4102

23.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0022 selon IG 0105.

Date: 26-09-12 Sceau: NT 4102

24.0

AAC1611

Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)
Polybond B46F N° de Lot: 1-29924-1

25.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG
0033.

Date: 27/09/12 Sceau: NT 4102



26.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10-55

Heure Fin Curing: 12-15

Date: 27/09/12 sceau:



27.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total: 2.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-37405-2

28.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

29.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod
Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Date: 28/09/12 Sceau:



30.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour le dernier plis. (un pli de 9 oz)

Date: 28/09/12 Sceau:



Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

31.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher 4 heures minimum.

Heure début Curing: 1:20

Heure Fin Curing: 8:00

Date: 28/09/12 Sceau:



32.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la piece

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.

Date: 1/10/12 Sceau:



33.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-37397-4

34.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air.

Corriger les imperfection de surface à l'aide du "Filler" P15-3 selon IG 0043

Laisser sécher jusqu'au lendemain

Date: 2 oct 12 Sceau:



Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

35.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le trimage du Pod Lid selon la IF134-0008.

Date: 11/10/12 Sceau:



36.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.4300 UNITE(s)/Unit Total : 0.4300 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-34195-2

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

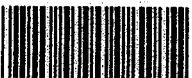
N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-34636-5

38.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 03/10/12 Sceau:



Fiche de Mélange: N/A

39.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

Date: 10/10/12 Sceau:



40.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-34195-2

41.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-34636-5

42.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Date: 25/10/12 Sceau:



Fiche de Mélange: N/A

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD LID

Numéro Job: 44975

Numéro DKC134-0073

Numéro Job:



Séq.:

Machine ou Opération:

Description :

43.0

INSPEC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

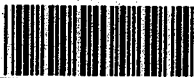
Date: 29 oct 12 Sceau:



44.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057


Date: 30-10-12 Sceau:



Date: Vendredi, 2012-09-21 10:04:24
 Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE	Nom Dessin : UTILITY POD BASE
Numéro Job : 44976	Numéro Article : DKC134-0075
Numéro : 4345	Numéro Dessin : D2202
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2012-09-21 No. :	Révision dessin : G
Prsht Rev. : NC	Matériel : Resine Darakane 470-36/411/510
Prem. fois : - - Type :	Date Dûe : 2012-09-28 Qté: 1 Ud UNITE
Job précédente : 43142	

 Écrit par : 
 Vérifié & Approuvé par :
 Commentaires : N° de Pièce Client: D2202-5

 Process Sheet Rév.: 02 AAC1885 était AC0883,
 AAC1887 était AC0884

COPIE

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
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1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment	Qty.: 0.030 UNITE(s)/Unit	Total : 0.030 UNITE(s)
	N° 83634, Frekote Loctite Wolo	# de Lot: 1-32783-4 1-37420-1

2.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule DKO-0331 selon IF134-0011.

Date: 1/16/12 Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment	Qty.: 1.250 KILOGRAMME(s)/Unit	Total : 1.250 KILOGRAMME(s)
	Gel Coat Blanc N° Gel 944W005	N° de Lot: 1-37214-2

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment	Qty.: 0.0095 GALLON(s)/Unit	Total : 0.0095 GALLON(s)
	Catalyst N° DDM-9	N° de Lot: 1-27829-1

5.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer le Gel Coat sur le moule selon IF134-0011.

Date: 1/10/12 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE
 Numéro Job: 44976

Nom Dessin: UTILITY POD BASE
 Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

6.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s)
 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-36539-2

7.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)
 Tissu à délaminer Release ply B

de Lot:

N/A 14

8.0 AAC1608 5oz plain weave Kevlar 50" wide roll

Comment Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)
 5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-28178-1

9.0 AAC1887 Wrighton 5200 Bleu P3

Comment Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)
 Wrighton 5200 Bleu P3

de Lot:

N/A 14

10.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

11.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 42.63 PIED(s)/Unit Total : 42.63 PIED(s)

12.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

13.0 AC1091 Film durisol # 3001792

Comment Qty.: 12.50 METRE CAR(s)/Unit Total : 12.50 METRE CAR(s)

14.0 TAILLAGE Faire le taillage du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le taillage du matériel et le matériel pour le Bagging selon IF 134-0011.

Date: 25-09-12 Sceau:



15.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)
 Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-37405-2

16.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)
 Catalyst N° DDM-9

N° de Lot:

1-27829-1

17.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus(verre et Kevlar) selon IF134-0011.

Date: 2/10/12 Sceau:



S.V



Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 44976

Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

18.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 12:30

Heure Fin Curing: 8:00

Date: 2/10/12 Sceau:



S.V



19.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.400 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-37405-2

20.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0

DKC134-0021

D2202-103 Foam Core (Utility pod Base)

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

D2202-103 Foam Core (Utility pod Base) N° de Job: 44977

22.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sceller le Foam Core N° DKC134-0021 selon IG 0105.

Date: 26-09-12 Sceau: NT-4102

23.0

AAC1611

Polybond B46F

Comment Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)

Polybond B46F N° de Lot: 1-29934-1

24.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Positionner et coller le Foam Core N° DKC134-0021 selon IF134-0011.

Date: 3/10/12 Sceau: S.V

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 44976

Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

25.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 3:00

Heure Fin Curing: 4:05

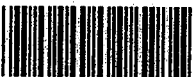
Date: 30/12

Sceau: S.V

26.0

DECOUPE

Découpe manuelle des pièces



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la découpe manuelle du foisonnement selon IG134-0011 point 8.5.

Date: 12/10/10

Sceau: 43

30

27.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.500 KILOGRAMME(s)/Unit Total : 2.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-37892-1

28.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

29.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des derniers tissés selon IF134-0011.

Date: 12/10/10

Sceau: 43

30

30.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 10:10

Heure Fin Curing: —

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 44976

Nom Dessin: UTILITY POD BASE
Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 12/10/12 Sceau:



31.0

AAC1615

D3001-1 Doubler (Pod Base D2002-3)

Comment Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)
D3001-1 Doubler (Pod Base D2002-3)

N° de Lot: B 85393

32.0

AAC0102

Colle Araldite N° 2012 (50ml)

Comment Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s) 1 - 36790-1
Colle Araldite N° 2012 (50ml) N° de Lot: 1 - 38133-1

33.0

ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Coller les trois doublers N° D3001-1 selon IF134-0011.

Faire trois petites poches à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 1.50

Heure Fin Curing: 2.20

Date: 17-10-11 Sceau:



34.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.030 GALLON(s)/Unit Total : 0.030 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1 - 37873-1

35.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doublers à l'aide du
"Filler" P15-3 et laisser sécher.

Date: 18-01-12 Sceau:



36.0

AAC1680

D3048-1 Doubler

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
D3048-1 Doubler

N° de Lot: 1 - 37554-1

37.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus pour épaissir et installer le grand doubler selon IF134-0011.

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 44976

Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 22/10/12 Sceau:



38.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.060 GALLON(s)/Unit Total : 0.060 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

de Lot: 1-32872-1

39.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la finition de l'intérieur selon IG 0043.

Vérifier la surface intérieure du Pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine aux endroits où il y a des bulles d'air.

Corriger les imperfections de surface à l'aide du "Filler" P15-3.

Laisser sécher jusqu'au lendemain.

Date: 24/10/12 Sceau:



40.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la pièce.

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide d'un manche de tournevis.

Date: 24/10/12 Sceau:



41.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le trimage selon IF134-0012.

Date: 24/10/12 Sceau:



Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 44976

Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

42.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-34195-2

43.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-34636-5

44.0

PRÉPARATION.

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 24/10/12 Sceau:



45.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 25-10-12 Sceau:



de Fiche technique: N/A

46.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Poncer le "Primer" batisseur selon IG 0008.

Date: 26-10-12 Sceau:



47.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-34195-2

48.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-34636-5

49.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 29-10-12 Sceau:



Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: UTILITY POD BASE

Numéro Job: 44976

Numéro DKC134-0075

Numéro Job:



Séq.:

Machine ou Opération:

Description :

50.0

INSPEC FINAL

Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 30 oct 12 Sceau:



51.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057.

Date: OCT 30 2012

Sceau:

